

(7) A

Dart Aerospace Ltd.

Date: Monday, 5/15/2006 11:12:13 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 27117		
Estimate Number	: 10940		
P.O. Number	: NIA	Part Number	: D29381
This Issue	: 5/15/2006 S.O. No. : NIA	Drawing Number	: D2938 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 25148	Material	: NIA
Written By	: <i>See Comment Below</i>	Due Date	: 5/30/2006
Checked & Approved By	: <i>06.05.15. W</i>	Qty:	8 Um: Each
Comment	: Est: 00.06.26 New DWG rev (mpp 2069) EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: *B24891*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

*JL/SA 06.06.13*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*JL/SA 06.06.13*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*JL/SA 06.06.13*

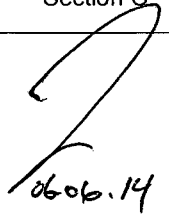
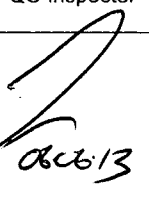
5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*mp 06/06/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.06.12	2	AREA AROUND SADDLE-TO-SKID ATTACHMENT HOLES WAS MACHINED TOO DEEP.	CP 06.06.13 per Q51042	SCRAP destroy & replace	J.L 06/06/12	 06.06.14	CP 06.06.13 per Q51042	 06.06.13

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:12:14 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27117

Part Number: D29381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/06/17

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/20

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 6/6/20 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51476

DL 6/6/20 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/06/20 (8)

Job Completion



a 8/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27117
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.121	.119	.120		
B	0.100	0.140		.121	.121	.121	.121		
C	0.100	0.140		.119	.119	.118	.118		
D	0.210	0.230		.221	.220	.222	.224		
E	1.245	1.255		1.250	1.251	1.251	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.501	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.578	1.577	1.577		
J	2.495	2.505		2.501	2.500	2.501	2.501		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240			.239	.238	.239		
N	0.100	0.140		.120	.121	.122	.122		
O	0.540	0.560		.551	.551	.548	.549		
P	0.490	0.510		.503	.502	.501	.493		
Q	3.715	3.725		3.720	3.719	3.720	3.720		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.253	.252	.250	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.631	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.259	1.261	1.261	1.262		
Y	1.565	1.585		1.572	1.573	1.574	1.576		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J-L	Audited by: J-L
Date: 06/06/12	Date: 06/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27117
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.120	.122	.124		
B	0.100	0.140		.122	.121	.122	.126		
C	0.100	0.140		.119	.117	.122	.120		
D	0.210	0.230		.223	.229	.226	.227		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.501	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.501	2.500	2.500	2.501		
K	0.257	0.262	DT8683	—	—	—	—		
L	0.312	0.317	DT8686	—	—	—	—		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.127	.127	.125		
O	0.540	0.560		.549	.549	.547	.548		
P	0.490	0.510		.498	.496	.501	.494		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.752	2.752	2.752	2.752		
S	0.240	0.270		.250	.250	.254	.253		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	—	—	—	—		
X	1.250	1.270		1.262	1.269	1.265	1.264		
Y	1.565	1.585		1.576	1.580	1.578	1.579		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA
Date:	06.06.13

Audited by:	TM
Date:	06/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg:</b> D2938 Rev. B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125					
B	0.100	0.140		.123					
C	0.100	0.140		.119					
D	0.210	0.230		.223					
E	1.245	1.255		1.250					
F	1.245	1.255		1.250					
G	2.495	2.505		2.500					
H	0.510	0.515		.514					
I	1.572	1.582		1.577					
J	2.495	2.505		2.500					
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.238					
N	0.100	0.140		.123					
O	0.540	0.560		.548					
P	0.490	0.510		.501					
Q	3.715	3.725		3.720					
R	2.720	2.760		2.752					
S	0.240	0.270		.254					
T	0.100	0.180		.145					
U	1.625	1.635		1.630					
V	1.362	1.372		1.367					
W	0.316	0.321	DT8690						
X	1.250	1.270		1.262					
Y	1.565	1.585		1.577					
Z			the replacement						
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SN
Date:	06.06.13

Audited by:	me
Date:	06/06/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

